

Date: Wednesday, 07/01/2009 1:36:52 PM
 User: Julie Dawson

Process Sheet

*Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: STA 155 BRACKET		
Job Number	: 44476			Part Number	: D28042		
Estimate Number	: 11040			Drawing Number	: D2804 REV C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 07/01/2009	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 23/01/2009 Qty: 8 Um: Each		
Previous Run	: 41740						
Written By							
Checked & Approved By	<u>Jul 09 01.09</u>						
Comment	Est. A00.11.06 New Issue EC Est. B06.05.30 Blanks on wtjetEC Est Rev:C As per Rev C 06-11-09 JLM Est Rev:D Removed Tumbling 08-09-10 JLM Verified By:EC						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6B0500X12000	6061-T6 Bar .500 x 12.00	
		Comment: Qty.: 0.7875 f(s)/Unit Total : 6.3000 f(s) 6061-T6 Bar .50" x 12.0" Material: 6061-T6 bar 12.00" x 0.50"	
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Template DT8534 Dwg Rev: <u>C</u> AB 9-1-12 Prog Rev: <u>C</u>	
		2-Deburr if necessary	
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	
		Comment: HAAS CNC VERTICAL MACHINING #1 Machine as per folio FA103	
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

88/09/01/20

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



AWB 9-1-23

X8

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

7.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC 9/1/23 (F)

8.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PC 9/1/23 (F)

9.0 QC21 FINAL INSPECTION/W/O RELEASE



09/01/2009

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MUF 09-01-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2804-2 PAR #: N/A Fault Category: Machin NCR: Yes No DQA: AB Date: 09.01.26
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: J Date: 09.01.28

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng .	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09/01/14	3.0	.757 Hole is not machine found because it did not tight piece piece properly operator error	<u>P</u> 09.01.14 per 09.01.14	Scrap and Destroy ⇒ Qty <u>X1</u> And replace B <u>109253</u>	09/01/14 MMF	<u>S</u> 09.01.14 per 09.01.14	<u>P</u> 09.01.14 per 09.01.14	<u>S</u> 09.01.14

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	44474
Description: STA 155 Bracket	Part Number:	D2804-2
Inspection Dwg: D2804 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

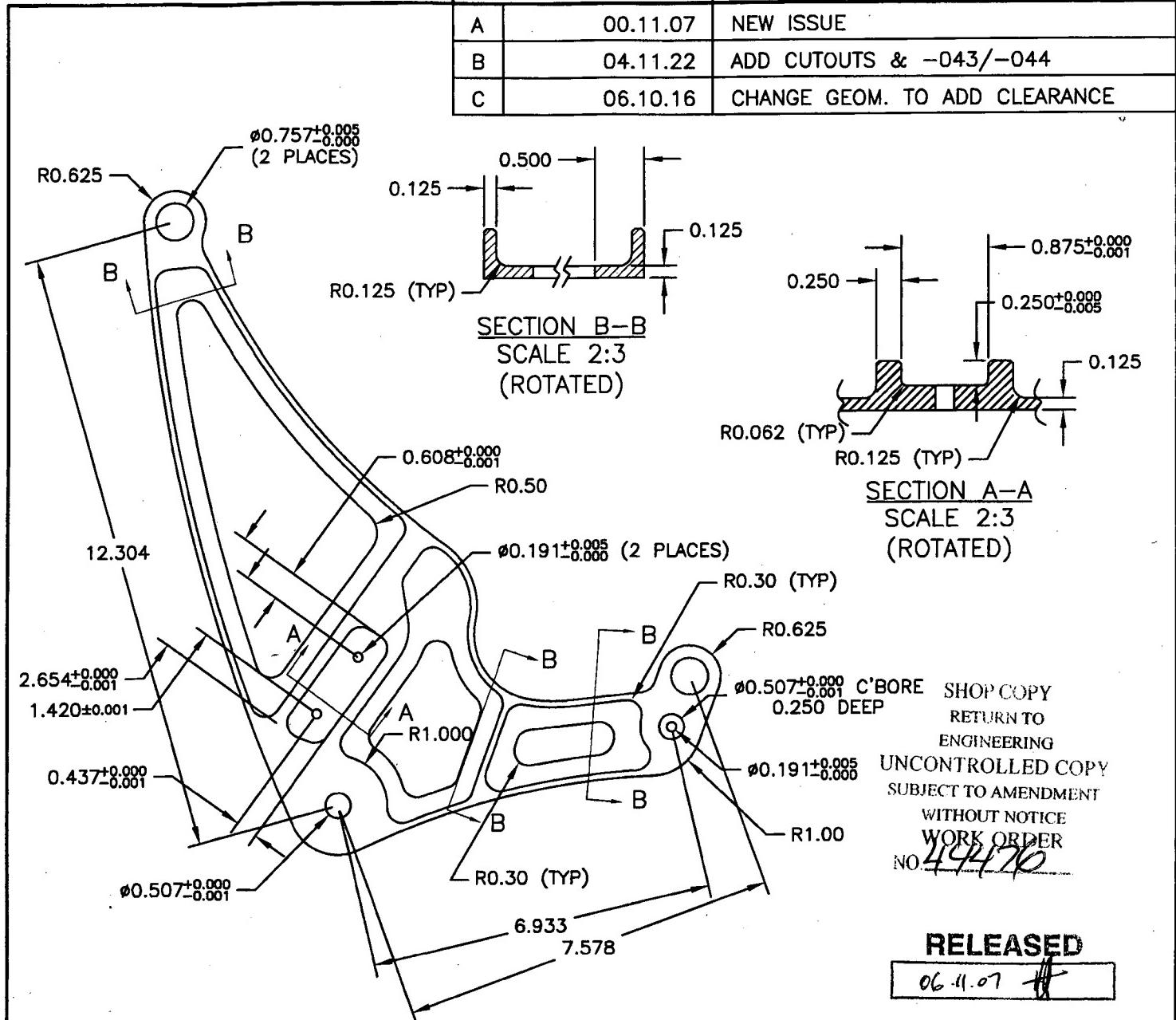
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.125	+/-0.010	.126	✓			
0.125	+/-0.010	.124	✓			
R0.125	+/-0.010	R.125	✓			
0.250	+/-0.010	.250	✓			
0.250	+0.000/-0.005	.249	✓			
0.875	+0.000/-0.001	.874	✓			
R0.062	+/-0.010	R.062	✓			
Ø0.757	+0.005/-0.000	Ø.756	✓			
R0.625	+/-0.010	R.625	✓			
12.304	+/-0.005	12.302	✓			
Ø0.507	+0.000/-0.001	Ø.506	✓			
0.437	+0.000/-0.001	.437	✓			
0.608	+0.000/-0.001	.608	✓			
Ø0.191	+0.005/-0.000	Ø.191	✓			
1.420	+0.001/-0.001	1.419	✓			
0.250 deep	+/-0.010	.250	✓			
6.933	+/-0.005	6.932	✓			
7.578	+/-0.005	7.577	✓			
0.500	+/-0.010	.500	✓			

Measured by:	MW	Audited by:	SP	Prototype Approval:	N/A
Date:	09/01/14	Date:	09/01/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.12.10	New Issue	KJ/JLM	
B	05.04.25	Added 0.500 dimension	KJ/JLM	
C	06.11.10	Revised per drawing revision C	KJ/JLM SP	EE

DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D2804	REV. C SHEET 1 OF 2
DATE 06.10.16	TITLE STA 155 BRACKET	SCALE 1:3	
A 00.11.07	NEW ISSUE		
B 04.11.22	ADD CUTOUTS & -043/-044		
C 06.10.16	CHANGE GEOM. TO ADD CLEARANCE		



RELEASED

06-11-07 *H*

D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

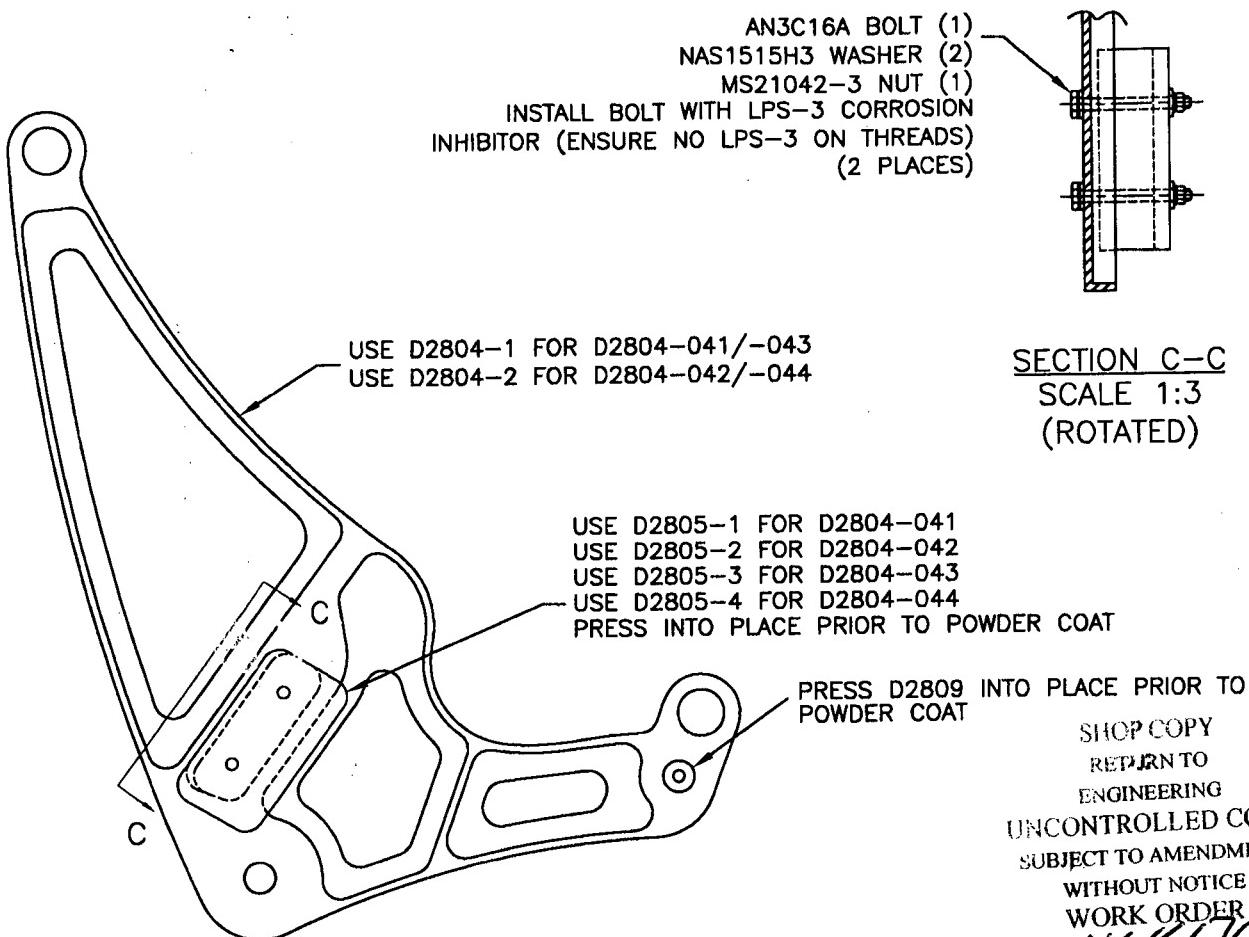
- 1) MACHINE PER DRAWING FILE "D2804-1C.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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DART

DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2804	REV. C SHEET 2 OF 2
DATE 06.10.16		TITLE STA 155 BRACKET	SCALE 1:3



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 44474

RELEASED

06.11.07 *[initials]*

D2804-041/-043 BRACKET ASS'Y (SHOWN)

D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

- 6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANTEX (4.3.5.6) OR BLACK SANTEX (4.3.5.7) OR GREEN SANTEX (4.3.5.8) PER DART QSI 005 4.3